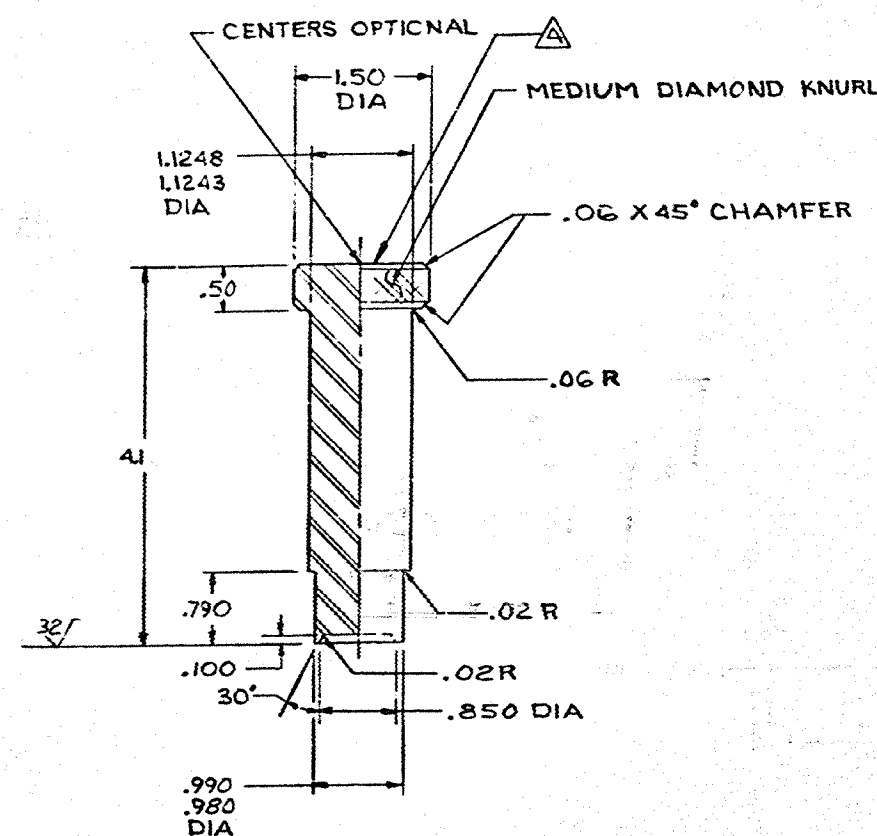


TOOL USAGE BLOCK							
COLUMN	V2	V3	V4	V5	V6	V7	V8
PART	REMARK	COL NO.	OPERATION	PART NO. & NAME	OPERATION	PART NO. & NAME	ASSY NO.
1		T101572	INSTALLING REMOVING	KWB9N BEARING	INTC FROM	204-040-785 SPIDER	204-040-784

RELEASED FOR PROD.
DATE: 9/62 / 4 INT: QU

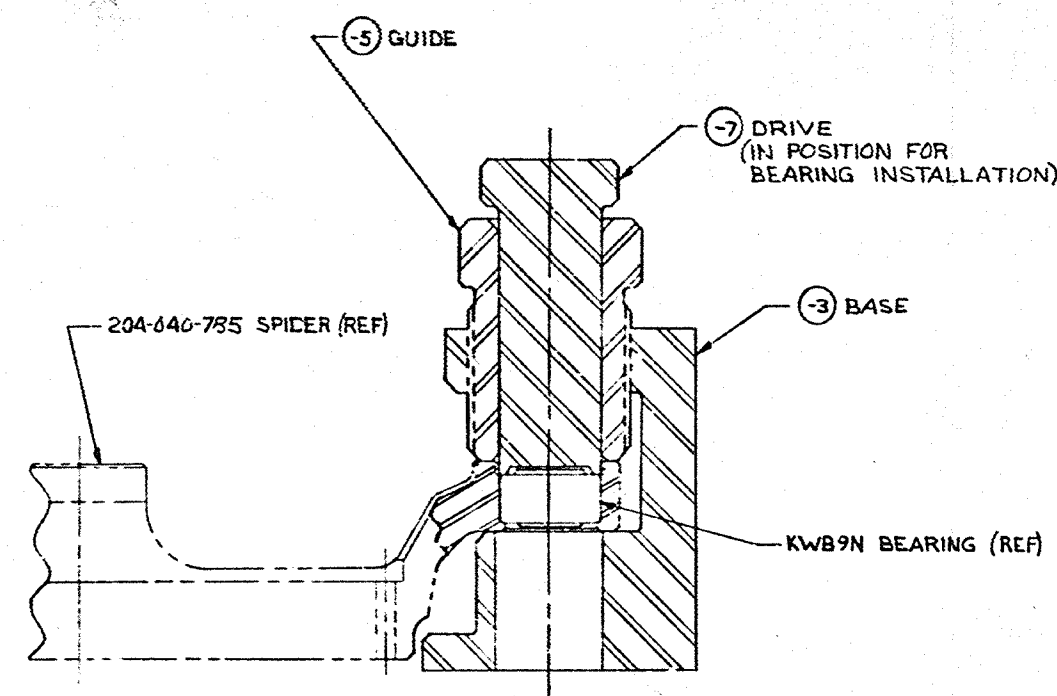


DETAIL OF -P PUNCH

9) PUNCH
(IN POSITION FOR
BEARING REMOVAL)

3) BASE

KWB9N BEARING (REF)



STEEL STAMP TOOL NUMBER PER BPS FW 4050

AXIS OF THREADS TO BE SQUARE TO SURFACE "B" &
CONCENTRIC TO DIA "C" WITHIN .001

AXIS OF THREADS TO BE SQUARE TO SURFACE "A"
WITHIN .002

BREAK ALL SHARP EDGES .015 X 45° CHAMFER OR .015R.

NOTES:

F 2

REVISIONS									
ZONE	DATE	DESCRIPTION	DATE	APPROVED	ZONE	DATE	DESCRIPTION	DATE	APPROVED
A		SEE 204-040-785, ADDED							
		CUSTOMER SIGNATURE							

LAST SECTION: C									
LETTER USED									

LIST OF MATERIAL OR PARTS									
ITEM NO.	DESCRIPTION	QUANTITY	UNIT	MATERIAL	STOCK SIZE	MATERIAL SPEC.	THICKNESS	LENGTH	ZONE
1	T101572-1 PUNCH	1	PC	4340 STL	COML				
2	T101572-2 DRIVE	1	PC	4340 STL	COML				
3	T101572-3 GUIDE	1	PC	4340 STL	COML				
4	T101572-4 BASE	1	PC	4340 STL	COML				
5	T101572-5 ALIGNMENT FIXTURE	1	PC	4340 STL	COML				

SECURITY CLASS	DWG NO	SHEET
	T101572	1

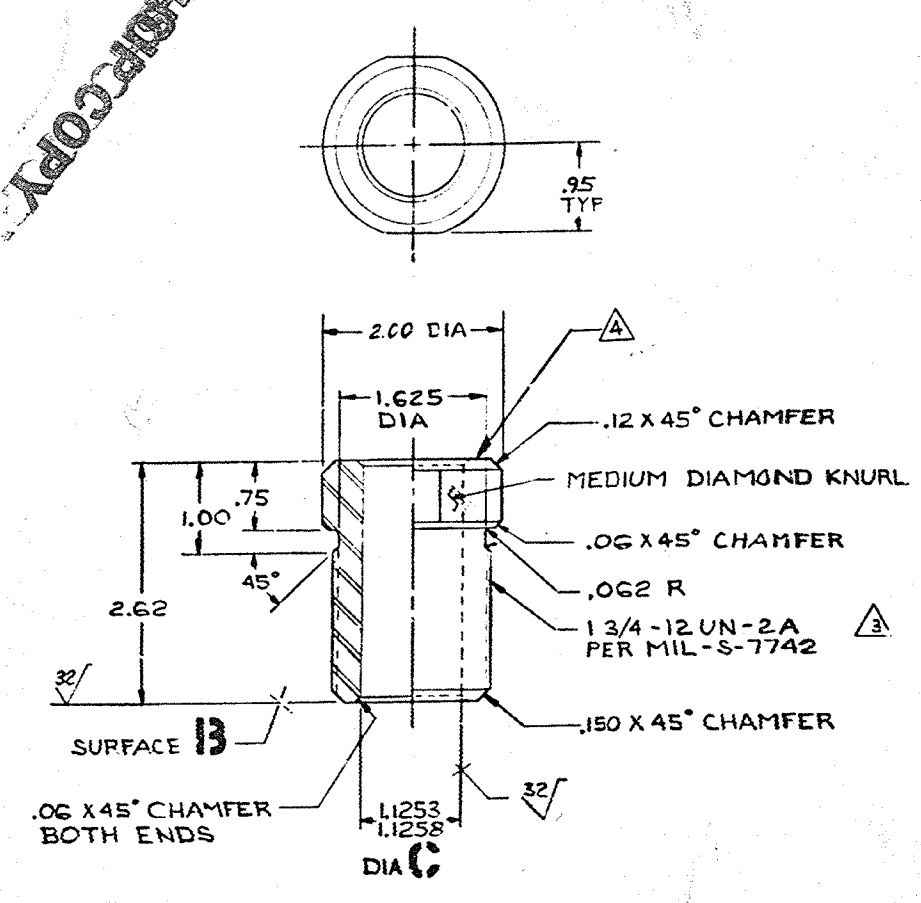
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THE FOREGOING DOES NOT APPLY TO VENDOR PARTS.

BPS FW 4140									
ITEM NO.	DESCRIPTION	QUANTITY	UNIT	MATERIAL	STOCK SIZE	MATERIAL SPEC.	THICKNESS	LENGTH	ZONE
1	T101572-1 PUNCH	1	PC	4340 STL	COML				
2	T101572-2 DRIVE	1	PC	4340 STL	COML				
3	T101572-3 GUIDE	1	PC	4340 STL	COML				
4	T101572-4 BASE	1	PC	4340 STL	COML				
5	T101572-5 ALIGNMENT FIXTURE	1	PC	4340 STL	COML				

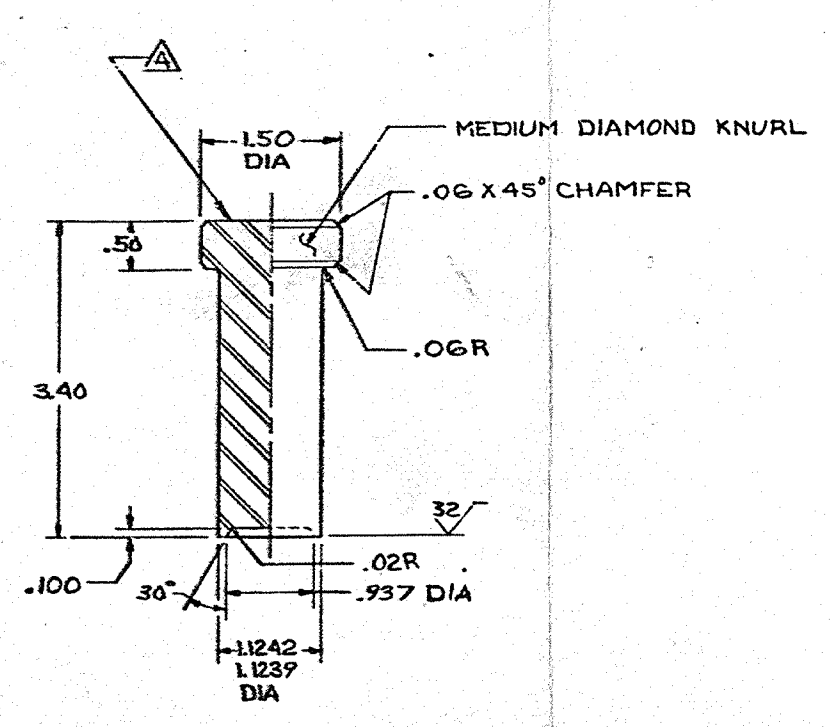
NO. 101235 REV. V 2ND NO. 01

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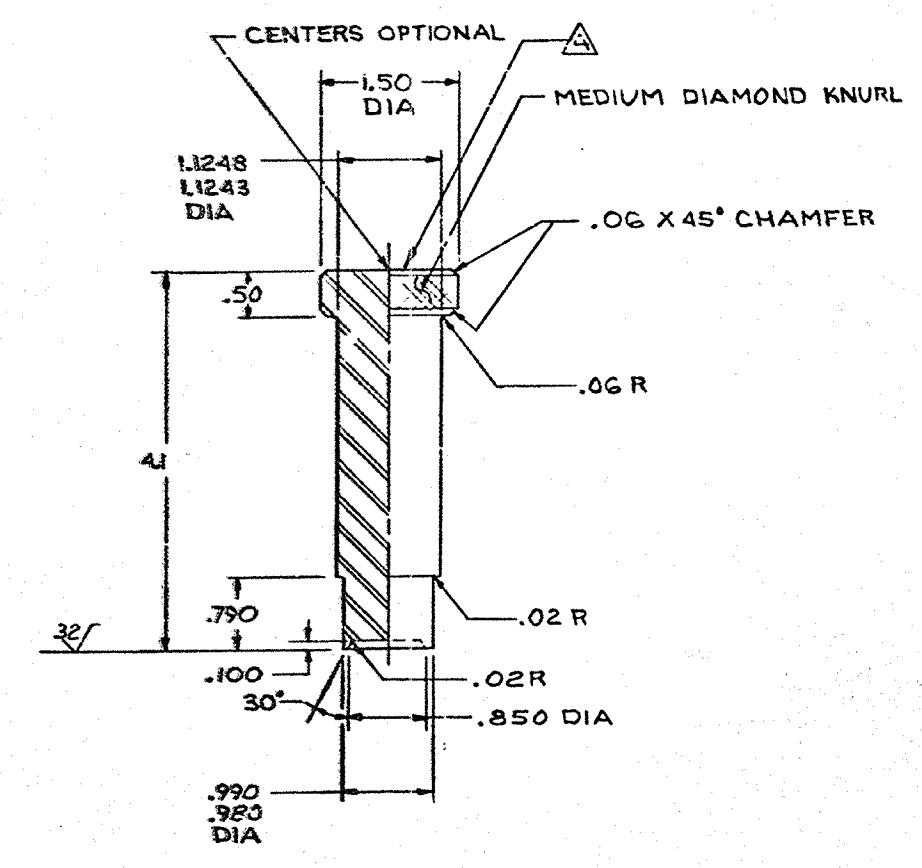


DETAIL OF -5 GUIDE

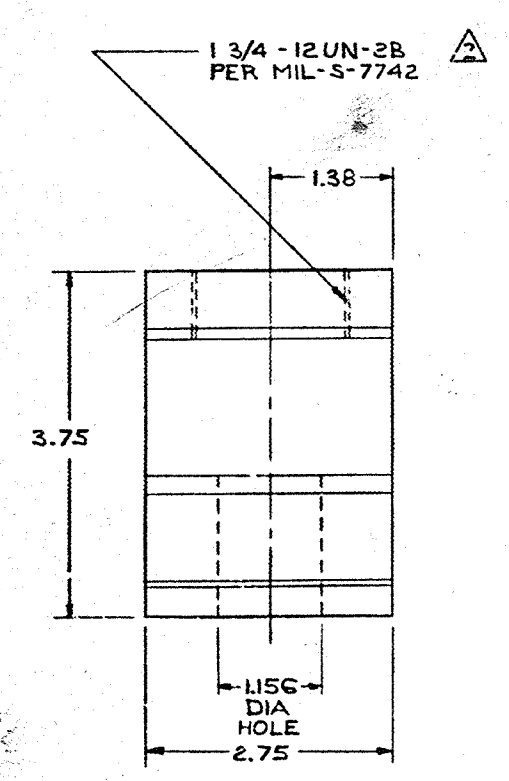


DETAIL OF -7 DRIVE

TOOL USAGE BLOCK							
COLUMN	V2	V3	V4	V5	V6	V7	V8
PARA	REMARK	TOOL NO.	OPERATION	PART NO. & NAME	OPERATION	PART NO. & NAME	ASSY NO.
1		T101572	INSTALLING	KWB9N BEARING	INTO	204-040-785 SPIDER	204-040-784



DETAIL OF -9 PUNCH



DETAIL OF -3 BASE

